



Dart Aerospace Ltd.
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K6A 1K7
Canada

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D4040-1
Job Sheet 187130



Part No: D4040-1

Part Name: Radius Block



Part Weight: 0 lbs

Job Created: 11/28/18

Due Date: 12/14/18

Type: **SOLD**

Note: DWG REV A lpp Rev:A New Issue 09-12-14 JLM Verified By:EC

Ship Via:

Job Qty: 10 ea

12 ea

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Machining-2		19/01/19
100	Bandsaw	10 pcs	12/14/18	12/14/18	0.00	0.00	Bandsaw1		19/01/19
105	CNC Vertical Machining	10 pcs	12/14/18	12/14/18	0.08	0.70	HAAS1-4		19/01/19
120	QC	10 pcs	12/14/18	12/14/18	0.00	0.00	QC8 Machining-2		19/01/19
130	HandFinish	10 pcs	12/14/18	12/14/18	0.00	0.34	HandFinish1		19/01/19
150	QC	10 pcs	12/14/18	12/14/18	0.00	0.00	QC3		19/01/19
160	Packaging	10 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-2	57021 90	19/01/19
170	QC21-SA	10 Ea	12/14/18	12/14/18	0.00	0.00	QC21		19/01/19

Part Op 100 - CUT BLANK 6.050" LONG 1 BLANK MAKES 6 PARTS
Descriptions: 105 - MILL AS PER DWG AND FOLIO FA890

DAG
21
A-09

JAN 18 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X0.750	6061T6 Bar .375 X .750	.9000 ft (.09 ea)	90-Start up Operation	5095016=1.09

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.375X0.750	1	25	0

Part Specifications

Target/Tolerance	Limits	Type	Special Comments
inches ± 0.030	0.320 0.260		
inches ± 0.030	0.780 0.720		
inches ± 0.030	0.780 0.720		
inches + 0.006 - 0.001	0.322 0.315	Diameter	
Inches ± 0.030	0.410 0.350		
Inches ± 0.030	0.280		

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Date: 01/14/19

Plex 11/28/18 8:40 AM Dart.lajeunesse.marie



Container No: S144532



Part: D4040-1

Job No: 187130

Serial No/Batch: S144532

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

			0.220	
7	Radius Block	45.000Degrees ± 0.500	45.500	Angle
			44.500	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					